

Work Order ID 81250

March-12-12 1:27:48 PM

81250

Page 1

Item ID: D2432

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206 (24") Bearpaw

Start Date: 3/12/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 3/23/12 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00

120

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

W/M 12.03.13 (12)

130

0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

ST/PO 12/03/15

12 0

140

0.00

140

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

ST/PO 12/03/15

12 0

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location: _____

0.00

151

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

OK 12/03/19

12

12/3/19 (12)

12/3/2019
H12-03-20

Picklist Print

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Page 1

Work Order ID: 81250

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw

Start Date: 3/12/12

Required Date: 3/23/12

Start Qty: 12.00

Required Qty: 12.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black		Purchased	No			120	sf	692.5517	3.7	44.4			

Location

Loc Qty

Loc Code

MAT018

435.4273684

120035

73.4273684

120401

242

120972

120

MAT019

257.1243158

117321

74.6

117738

93.28

117819

83.3

118814

1.5

119145

4.44431579

WM 12-03-13

DART AEROSPACE LTD		Work Order: 81250
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.07 x 45°	✓		Vern	SL-3
B	5.500	+/-0.030	5.500	✓		~	
C	0.200	+/-0.030	.204	✓		-	
D	0.25 x 45°	+/-0.030	.25 x 45°	✓		-	
E	R0.250	+/-0.030	.250	✓		R-G	
F	0.250	+/-0.010	.252	✓		Vern	SL-3
G	0.625	+/-0.030	.623	✓		-	
H	0.375	+/-0.010	.382	✓		-	
I	0.950	+0.030/0.010	.958	✓		-	
J	19.000	+/-0.030	19.00	✓		m-tape	
K	3.14	+/-0.030	3.14	✓		Vern	SL-3
L	3.28	+/-0.030	3.28	✓		~	
M	Ø0.260	+0.005/-0.000	.260	✓		~	
N	Ø0.93	+/-0.030	.925	✓		~	
O	0.30	+0.030/-0.000	.308	✓		~	
P	23.750	+/-0.030	23.75	✓		m-tape	
Q	7.375	+/-0.030	7.346	✓		UG	
R	4.250	+/-0.010	4.250	✓		Vern	SL-3
S	2.000	+/-0.030	2.008	✓		~	
T	9.000	+/-0.010	9.000	✓		~	
U	9.000	+/-0.010	9.000	✓		~	
V	0.375	+/-0.010	.377	✓		~	

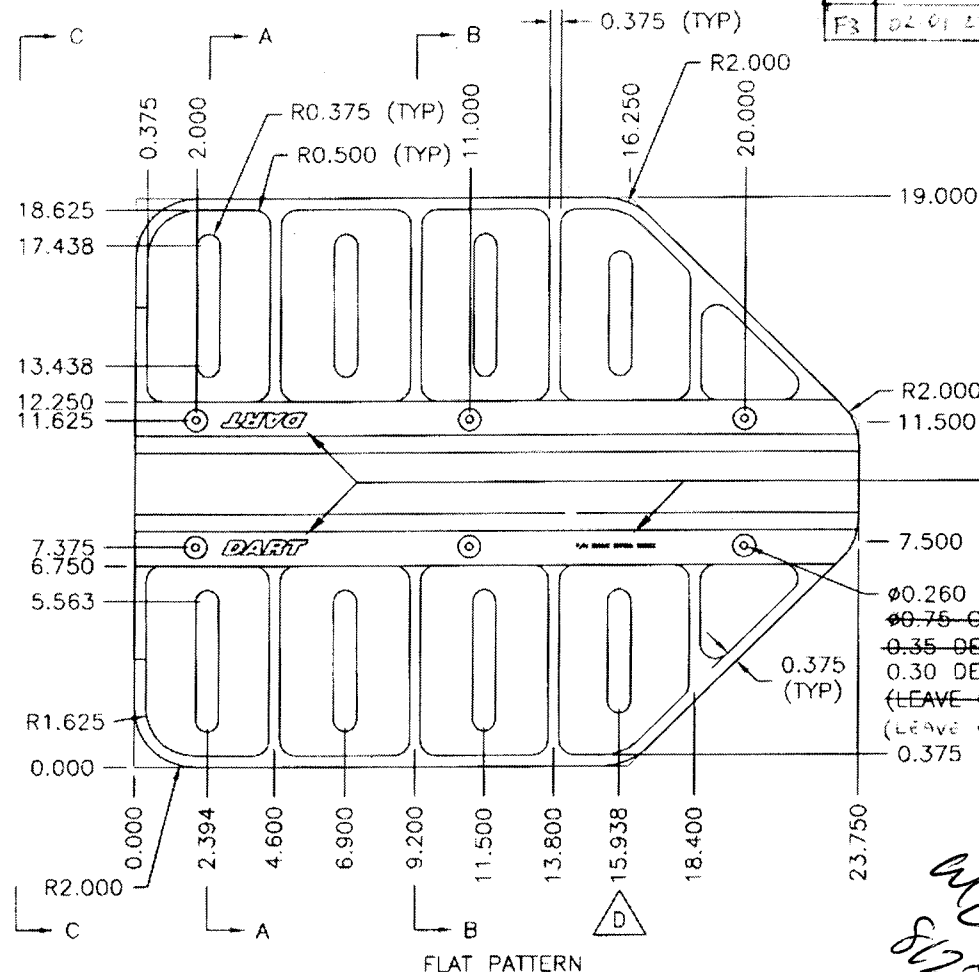
Measured by: SL	Audited by: [Signature]	Prototype Approval: N/A
Date: 12/03/14	Date: 12/03/14	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF [Signature]

F1	99.03.01	ADD DEC 9143
F2	01.03.28	ADD WAS DEC 75 14
F3	02.01.23	CLARIFY QRE DIMS 14 25

RELEASED
49.06.17 KG

DART



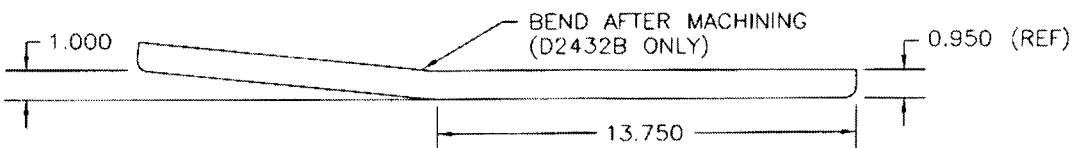
ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

~~Ø0.260 (TYP)~~
~~Ø0.75 C'BORE~~ ~~Ø0.13 C'BORE~~
~~0.35 DEEP FROM TOP (MIN.)~~
~~0.30 DEEP FROM BOTTOM~~
~~(LEAVE 0.300 MIN.)~~
~~(LEAVE 0.650 MIN.)~~
0.375



9143
8/2/80

EFFECTIVE	DEOS
9143	



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

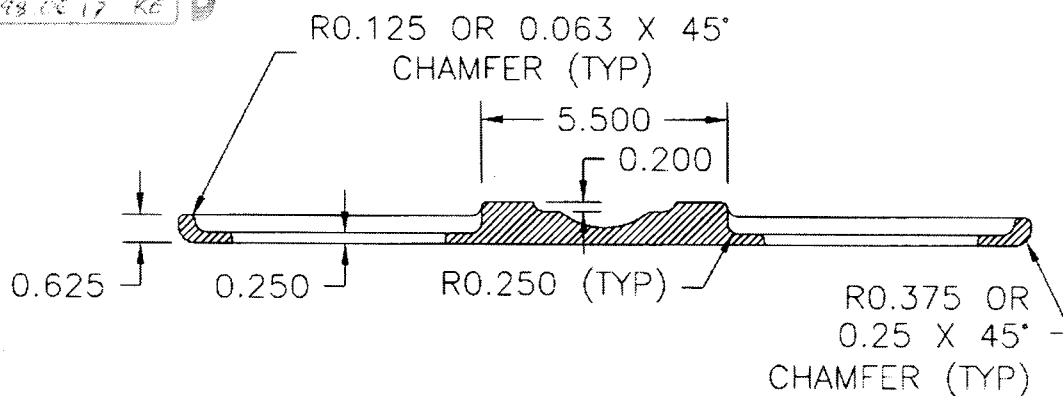
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. F
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2432	SHEET 1 OF 2
DATE 98.05.12	TITLE BEARPAW	SCALE 1:6	
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	

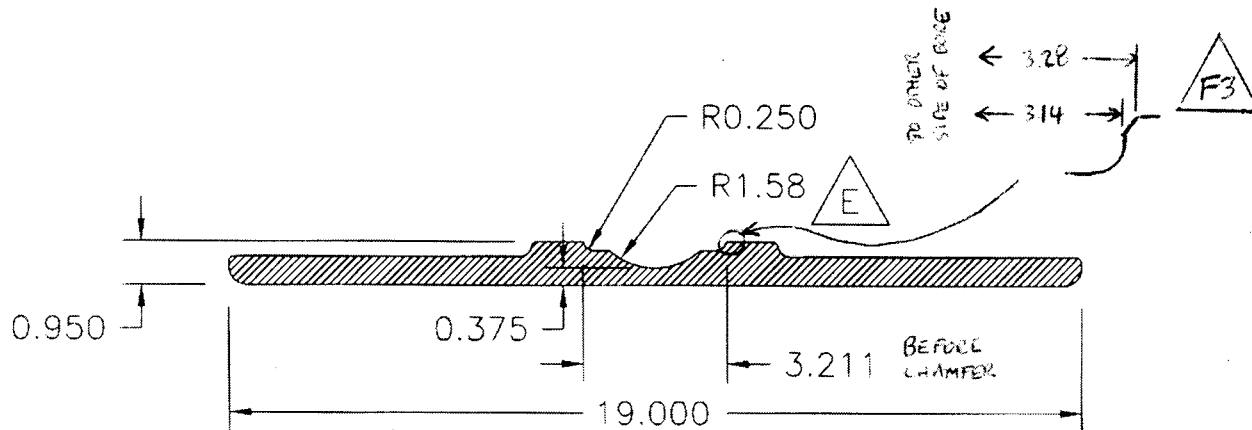


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED P.P.	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

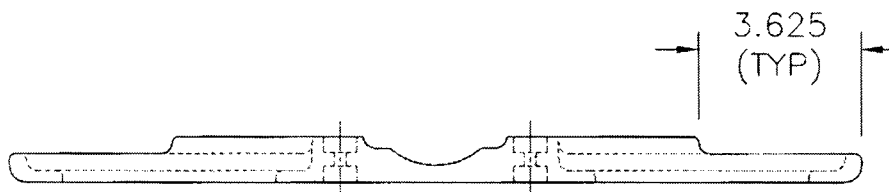
RELEASED
98 DEC 17 KE



SECTION A-A



SECTION B-B



SECTION C-C